

Date:
User:Friday, 22/05/2009 8:58:42 AM
Julie Dawson

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 48108 <i>2</i>		
Estimate Number	: 10272		
P.O. Number	:	Part Number	: D2562001
This Issue	: 22/05/2009 S.O. No. :	Drawing Number	: D2562 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	: 42101	Material	:
	Type : SMALL / MED FAB	Due Date	: 28/05/2009
Written By	:	Qty:	<i>3</i> Um: Each
Checked & Approved By	: <i>JLW 09.05.25</i>		
Comment	: Est F 02.04.15 Added dwg Rev.B1 NG		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W

*(3X)*

Comment: Qty.: 1.7920 f(s)/Unit Total: 17.9204 f(s)
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
 Batch *M 111097*

m-l 09/06/01

2.0 BRAKE NC NC BRAKE

*(3X)*

Comment: NC BRAKE
 Punch to length as per Dwg D2562

m-l 09/06/01

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

*(3X)*

Comment: SMALL/MED FAB RESOURCE
 1- Bend end as per Dwg D2562 Angle "D"
 2-Deburr

m-l 09/06/01

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/06/01 (X3)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

(3)

START TIME: *9:25*
 OVEN TEMPERATURE: *400°*
 FINISH TIME: *9:55*

FL 09/06/01

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 48108

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 09-06-01 (3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 264

9/6/01

(3)

SC

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01

Job Completion



MF 09-06-01

FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE
DART INSTALLATION INSTRUCTIONS.

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D206-648-011	GROUND HANDLING KIT
	X	D206-648-013	GROUND HANDLING KIT
8	8	D2652	BUSHING
2		D2659	GHW LUG
	2	D3414-041	LUG ASSEMBLY
4		AN3-37A	BOLT
	4	AN3C37A	BOLT
	4	AN960C10	WASHER
4		AN960JD10	WASHER
4		MS21042-3	NUT (OR MS21042L3)
	4	MS21043-3	NUT

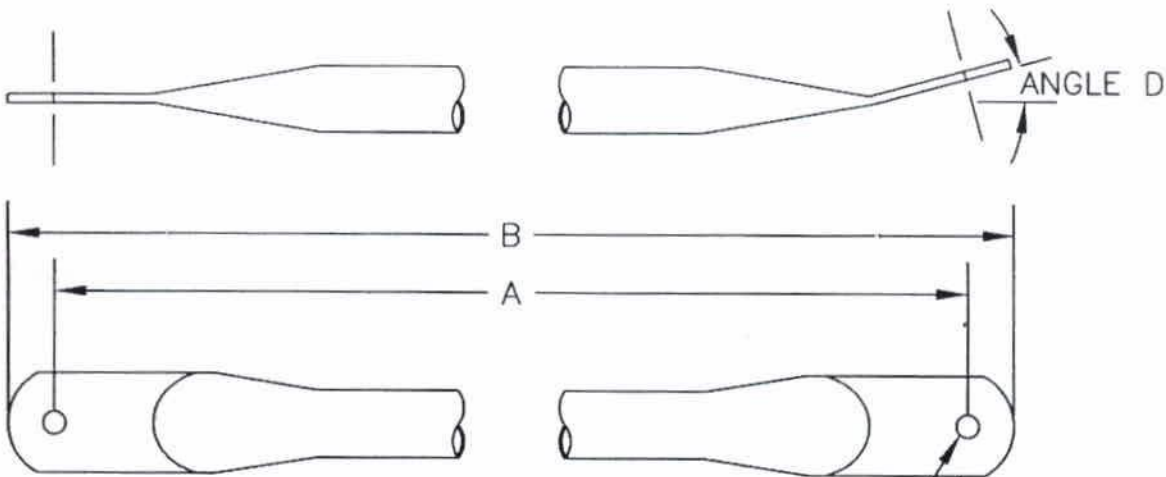
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WORK ORDER
NO 48108

RELEASED
09/24/16

B	INSTALLATION AND WEIGHT AND BALANCE INFORMATION TRANSFERRED TO DART INSTALLATION INSTRUCTIONS D206-642. ALL HARDWARE UPDATED TO SS HARDWARE.	AJS	08.09.24
A	NEW ISSUE	JB	97.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	D206-648	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GND HANDLING WHEEL (GHW) INSTL	NONE
DATE	08.09.24	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
CP	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2562	SCALE
DATE	TITLE		1:2
05.05.18	STRUT		
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005: ADD FINISH	
D	05.05.18	ADD -007/-011/-013: UPDATE -005	



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

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GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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